


Date: Sunday, 10/05/2009 7:59:28 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING
Job Number : 47828	
Estimate Number : 13926	
P.O. Number :	Part Number : D38841
This Issue : 10/05/2009 S.O. No. :	Drawing Number : D3884 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : PREL
Previous Run :	Material :
Written By :	Due Date : 17/05/2009
Checked & Approved By : MF 09-05-10	Qty :  Um : 4 Each
Comment : Est Rev:A New Issue 09-05-09 JLM Verified By:EC	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101017	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 7075-T7351 6.350 X6.250
 Make from D6101-017 billet for D3884-1/-2
 Ensure that grain is along 6.350 " length
 Batch No: B47460

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No: B47028 Double check by: mmf

1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA818 and inspect per attached Dimension Sheets
 4-Deburr

HA 09/06/02

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D3884

HA 09/06/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA 09/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Sunday, 10/05/2009 7:59:28 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING

Job Number: 47828

Part Number: D38841

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



**ENGINEERING
APPROVAL**



Comment: SECOND CHECK

CP 09.06.08 SF 09/06/09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/06/09 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M11472

START TIME:

2:00pm

OVEN TEMPERATURE:

3200F

FINISH TIME:

2:30pm

09-06-09

(22)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

** give to Jason M **

BR 09-06-9 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

assy on D 119-646-112 + 213

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE *09.05.11*

RELEASED

AUTH *mf 09-06-23*

DATE

ENG USE ONLY
CP 09.09.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	
Description:				Part Number:	
Inspection Dwg:	Rev:	DSK:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	R0.470	R0.530		R0.500	R0.500			
B	R0.620	R0.680		R0.650	R0.650			
C	1.220	1.280		1.250	1.250			
D	0.615	0.635		0.625	0.625			
E	0.490	0.510		0.498	0.500			
F	1.245	1.255		1.249	1.249			
G	2.495	2.505		2.500	2.500			
H	5.990	6.010		6.000	6.000			
I	1.245	1.255		1.250	1.249			
J	0.020x45°	0.040x45°		0.030x45°	0.030x45°			
K	0.313	0.318		0.317	0.317			
L	R0.280	R0.340		R0.310	R0.310			
M	R0.100	R0.160		R0.130	R0.130			
N	R0.021	R0.041		R0.032	R0.032			
O	R0.470	R0.530		R0.500	R0.500			
P	0.760	0.765		.760	.760			
Q	R0.015	R0.035		.030	.030			
R	0.235	0.255		.245	.245			
S	0.225	0.220		.220	.219			
T	0.051	0.071		.061	.061			
U	0.260	0.280		.272	.273			
V								
W								
X								
Y								
Z								
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by:	<i>[Signature]</i> 09.06.04	Date:	
Audited by:	<i>[Signature]</i> 09/06/04	Date:	
Prototype Approval:	<i>[Signature]</i> 09.06.08	Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	

DART AEROSPACE LTD				Work Order:	
Description:				Part Number:	
Inspection Dwg:		Rev:	DSK:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.140	0.165		0.165	0.165			
B	R0.470	R0.530		R0.500	R0.500			
C	0.257	0.262		0.260	0.260			
D	1.120	1.130		1.126	1.126			
E	2.245	2.255		2.250	2.250			
F	0.791	0.811		0.802	0.803			
G	0.843	0.863		0.852	0.852			
H	80.6°	81.6°		81.1°	81.1°			
I	0.886	0.906		0.898	0.898			
J	2.870	2.880		2.876	2.876			
K	1.433	1.443		1.438	1.438			
L	0.638	0.658		0.646	0.646			
M	0.110	0.140		0.140	0.140			
N	3.895	3.905		3.900	3.900			
O	0.604	0.624		0.614	0.614			
P	R2.000	R2.020		R2.003	R2.003			
Q	R0.470	R0.530		R0.500	R0.500			
R	R0.470	R0.530		R0.500	R0.500			
S	44.5°	45.5°		45°	45°			
T	0.040x45°	0.060x45°		0.050x45°	0.050x45°			
U	R0.178	R0.198		R0.188	R0.188			
V	0.115	0.135		0.124	0.124			
W	7°	8°		7.5°	7.5°			
X	0.140	0.165		0.155	0.154			
Y	R0.470	R0.530		R0.500	R0.500			
Z	0.620	0.680						
AA	2.826	2.886		2.870	2.870			
AB	0.240	0.260		0.253	0.253			
AC	0.110	0.140		0.140	0.140			
AD	R1.265	R1.285		R1.267	R1.266			
AE	0.316	0.321		0.320	0.320			
AF	3.350	3.410		3.390	3.390			
AG	1.745	1.755		1.750	1.750			
AH	0.990	1.010		1.004	1.004			
				Accept/Reject				

Measured by: *[Signature]*

Date: *09-06-04*

Audited by: *[Signature]*

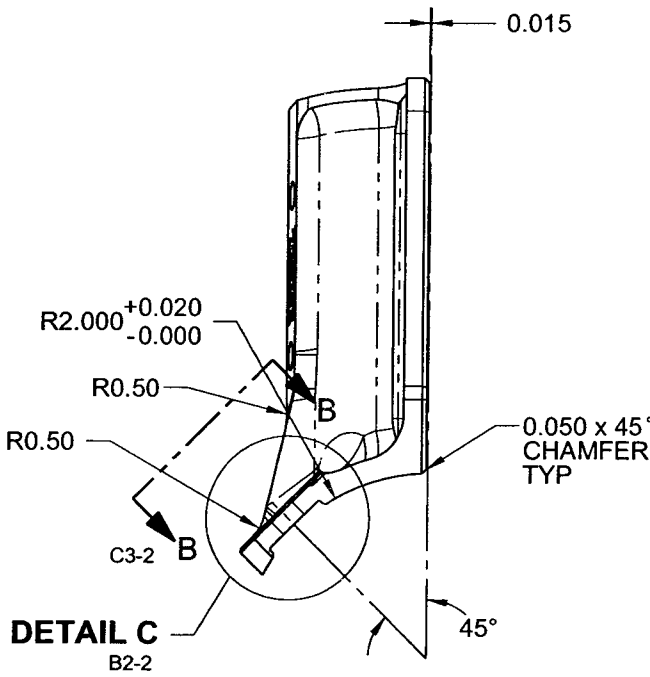
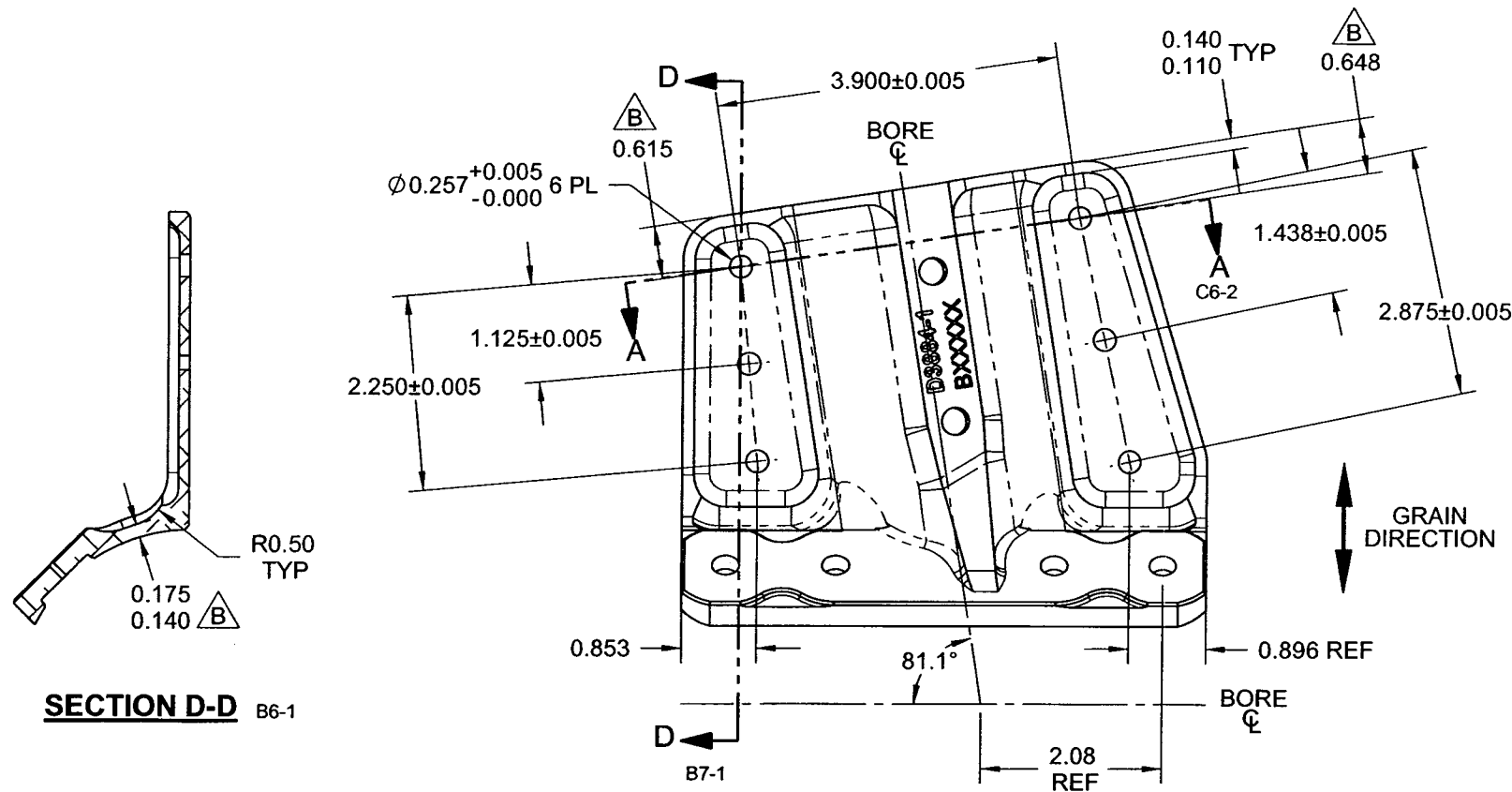
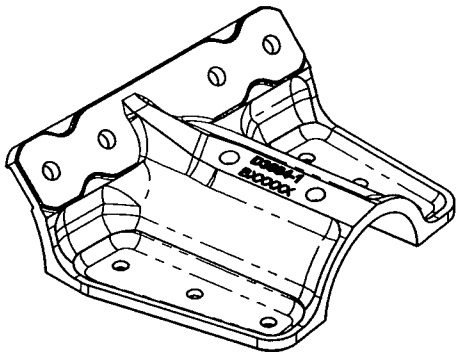
Date: *09/06/04*

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	

PRELIMINARY
ISSUE



SECTION D-D B6-1

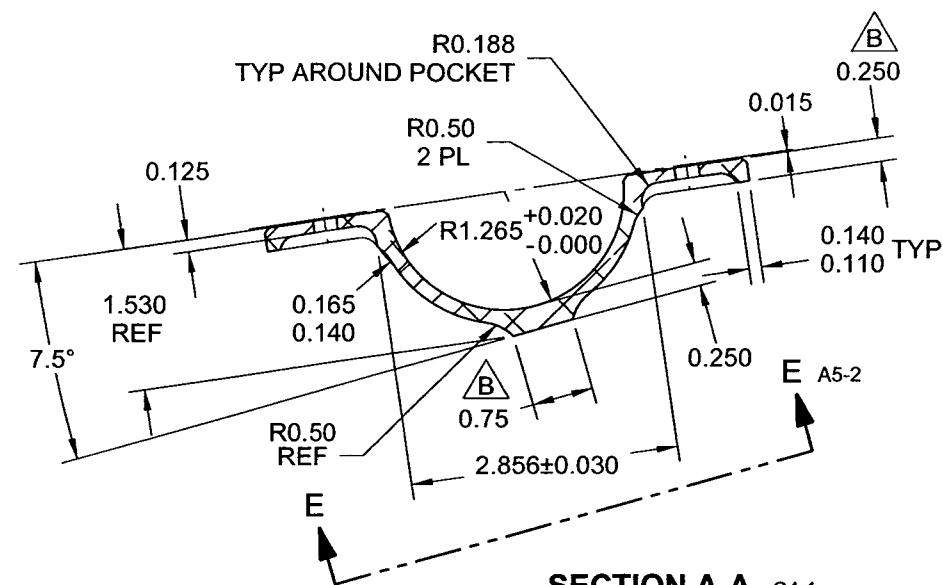
D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

PRELIMINARY

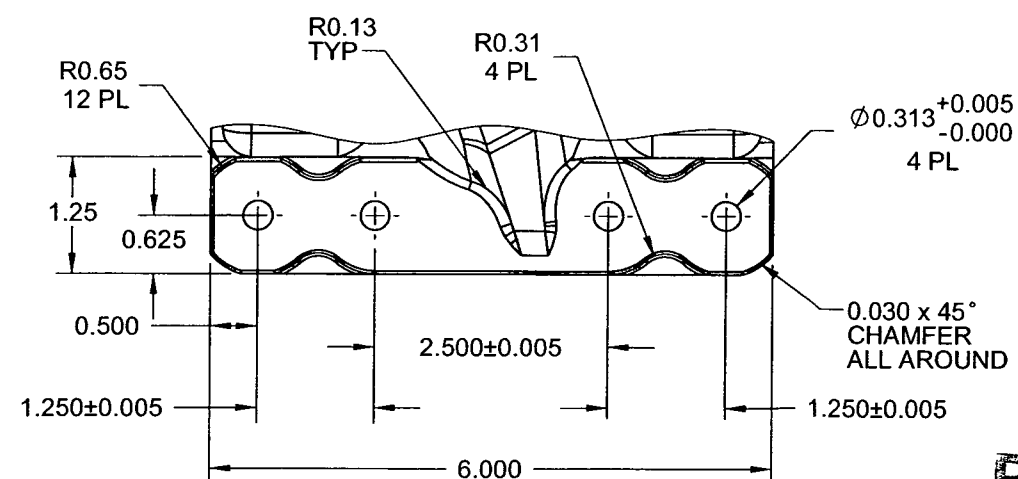
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.05
A	NEW ISSUE	RF	09.04.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.05	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



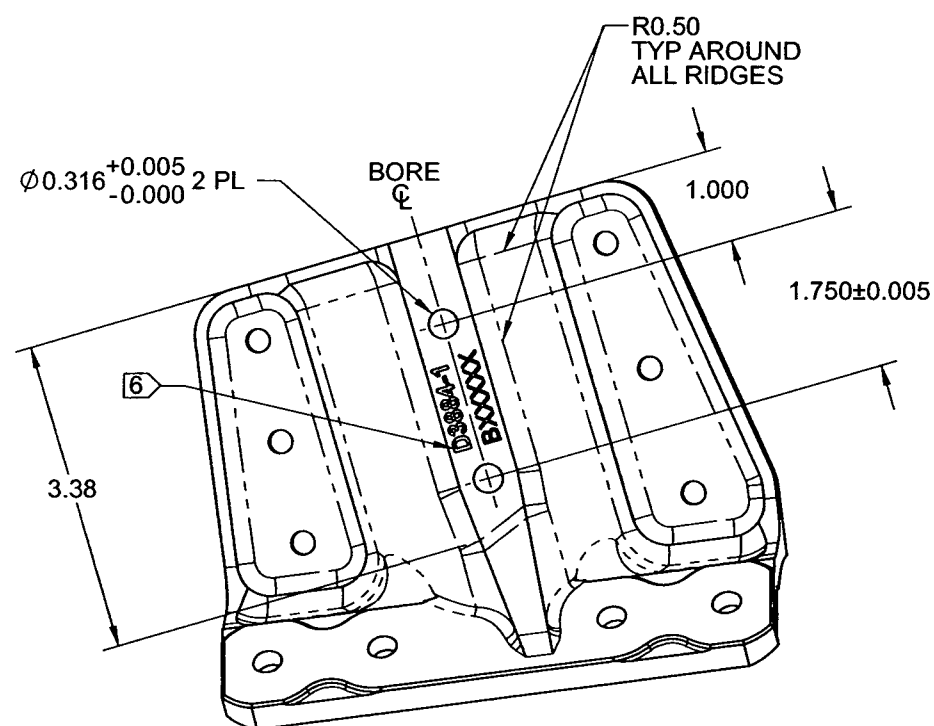
SECTION A-A C4-1



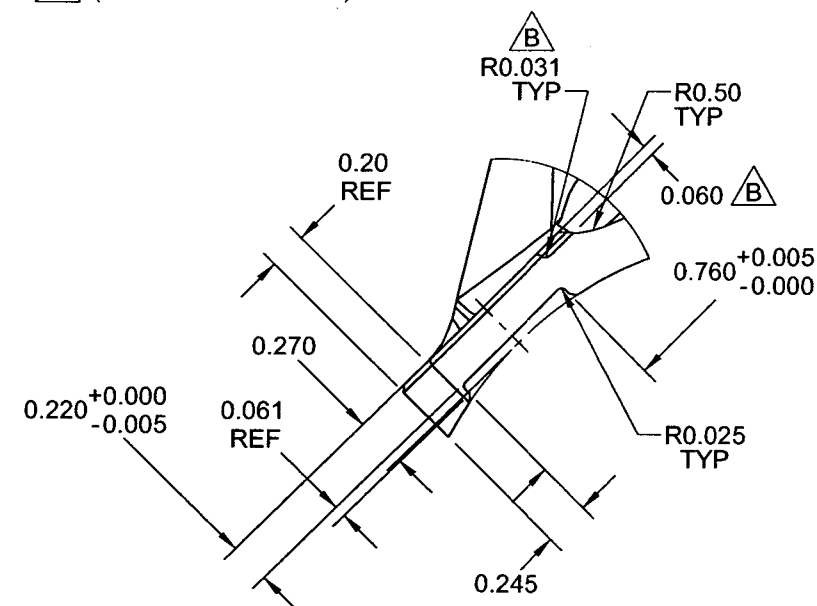
VIEW B-B B3-1
(ROTATED FOR CLARITY)

**PRELIMINARY
ISSUE**

09.06.05



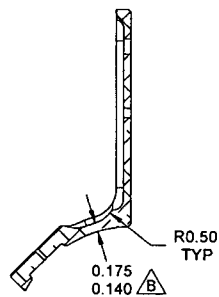
VIEW E-E C6-2



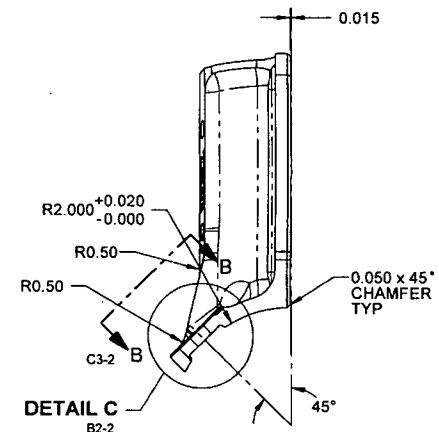
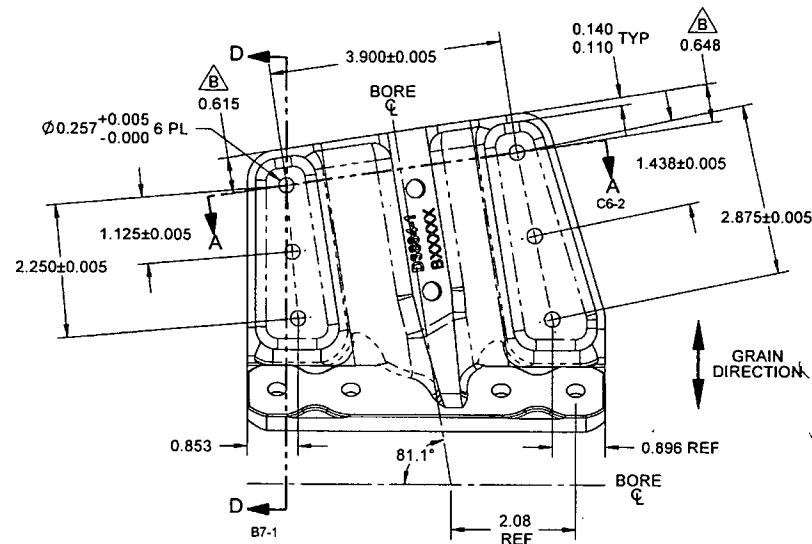
DETAIL C B3-1
SCALE 2X

PRELIMINARY

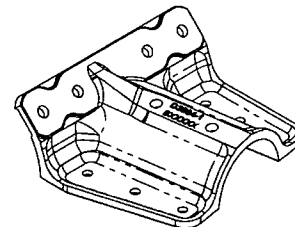
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.05	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



SECTION D-D B6-1



DETAIL C B2-2



**D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)**

RELEASED
01/15/14

47828

NOTES:

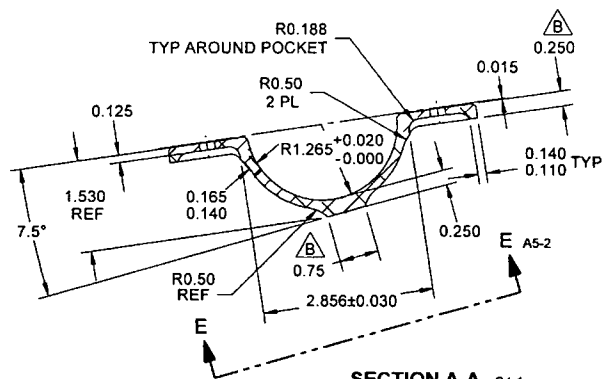
- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	PH		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

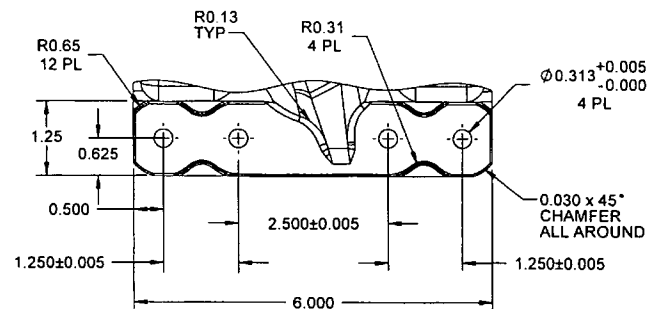
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3884** REV. B
SHEET 1 OF 2
TITLE **INBOARD SADDLE** SCALE NTS

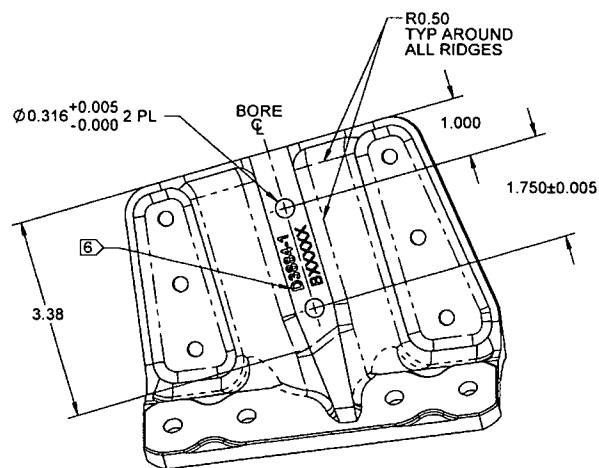
COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



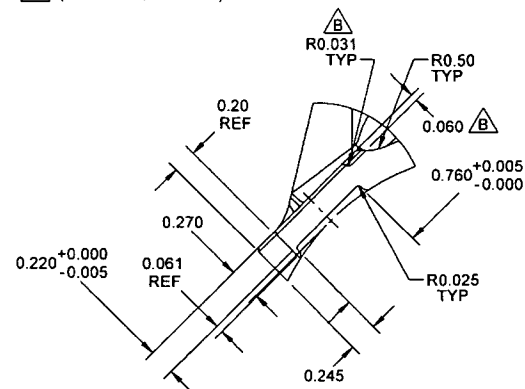
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

47828

RELEASED
2015/10/10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3884	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	INBOARD SADDLE	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	